

# Work Order ID 61999

Wednesday, September 15, 2010 9:53:55 AM



Page 1

Item ID:	D2523	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Mounting Bracket					
Start Date:	9/14/2010	Start Qty:	4.00		Cust Item ID:	
Required Date:	9/21/2010	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	10/2/15	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2523	Rev A2								

100		0.00							
	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blank: 21.75" x 12.00"								

*OK 10/09/26*

*4 0*

110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per folio D2523								

*SL 10/11/08*

*(4)*

120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

*SL 10/11/09*

*(4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



**NOTE:** Date & initial all entries




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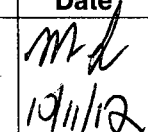
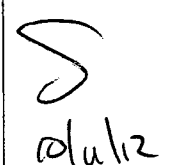

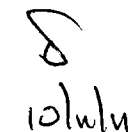

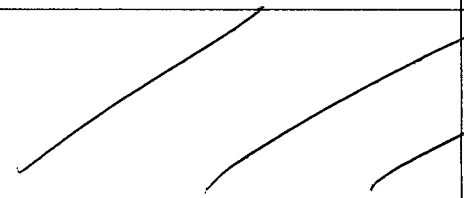

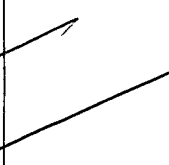
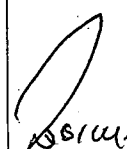
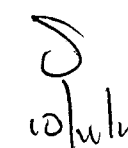
Item ID:	D2523	Accept		Setup	Start	
Revision ID:						
Item Name:	Mounting Braket				Stop	
Start Date:	9/14/2010	Start Qty:	4.00		Cust Item ID:	
Required Date:	9/21/2010	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		<i>10.11.9</i>		<i>4</i>			
140  Small Fab Small Fab	Small Fab  Memo Deburr <input type="checkbox"/> Drill holes as per dwg D2523 using DT8560	0.00  0.00		<i>= 7 m-k 10/11/10</i>		<i>(4X)</i>			<i>Pro -&gt;</i>
150  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00		<i>8.10.11.11</i>		<i>(+3)</i>	<i>(76)</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2523 PAR #: \_\_\_\_\_ Fault Category: Small Fts NCR: Yes No DQA: Yes Date: 10-11-17  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Yes Date: 10/11/17

NCR: <u>61999</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/11/17	#140	Found at inspection that Qty x1 holes on section "A" are off line. are hole measure .745 (should be .720) the other measure .662. (should be .720). R.C. Jg moved Lack of Attention		Scrap. Not acceptable For post transfer drilling	 10/11/17	 10/11/17	 10/11/17	 10/11/17
							 10/11/17	 10/11/17



NOTE: Date & initial all entries




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Item ID:	D2523	Accept		Setup	Start	
Revision ID:						
Item Name:	Mounting Braket				Stop	
Start Date:	9/14/2010	Start Qty:	4.00		Cust Item ID:	
Required Date:	9/21/2010	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
	HandFinish	0.00							
Hand Finishing	Memo								
170	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	Powdercoat	0.00							
Powder Coating	Memo								
	START TIME: 3:15								
	320° FINISH TIME: 3:45								
180	QC3- Inspect Part Finish	0.00							
	QC	0.00							
Quality Control	Memo								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 61999

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Item ID: D2523

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Bracket

Start Date: 9/14/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/21/2010 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190



Packaging

Packaging

Identify as per dwg & Stock Location: 199

0.00

Memo

0.00

*Signature* 10/14/16 (3)

200



QC

Quality Control

QC21- Final Inspection - Work Order Release .

0.00

Memo

0.00

*Signature* 10/11/16 *Signature*

mf

10-11-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, September 15, 2010 9:54:00 AM

Page 1

Work Order ID: 61999

Parent Item: D2523

Parent Item Name: Mounting Braket



Start Date: 9/14/2010

Required Date: 9/21/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP C01.04.16 Re format, added DT8560 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X12.00 0		Purchased	No			100	f	12.3750	1.8125	7.631579			



6061-T6 Bar 1.00 x 12.00



Location

Loc Qty

Loc Code

MAT

8.375

115255

8.375

MAT05

4

106701

4

3.806 *mt 10/09/26*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	41999
<b>Description:</b> Mounting Bracket		<b>Part Number:</b>	D2523
<b>Inspection Dwg:</b> D2523 <b>Rev:</b> A2		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.005/-0.000	.260	✓		Vern JL-3	
1.076	+/-0.010	1.077	✓		"	
1.985	+/-0.010	1.985	✓		"	
Ø0.257	+0.005/-0.001	.260	✓		"	
9.372	+/-0.010	9.372	✓		Vern SD-05	
1.035	+/-0.010	1.034	✓		Vern JL-3	
Ø0.191	+0.005/-0.000	.195	✓		"	
7.546	+/-0.010	7.546	✓		Vern SD-05	
2.776	+/-0.010	2.776	✓		Vern JL-03	
2.776	+/-0.010	2.776	✓		"	
0.875	+/-0.010	.872	✓		"	
R0.125	+/-0.010	.125	✓		R-G	
1.00	+/-0.030	.998	✓		Vern JL-3	
R0.125	+/-0.010	.125	✓		R-G	
0.750	+/-0.010	.753	✓		Vern JL-3	
0.250	+/-0.010	.246	✓		"	
R0.250	+/-0.010	.250	✓		R-G	
0.125	+/-0.010	.123	✓		mic 118-120	
R0.125	+/-0.010	.125	✓		R-G	
R0.063	+/-0.010	.063	✓		"	

<b>Measured by:</b>	SL	<b>Audited by:</b>	AP	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	10/11/08	<b>Date:</b>	10.11.9	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

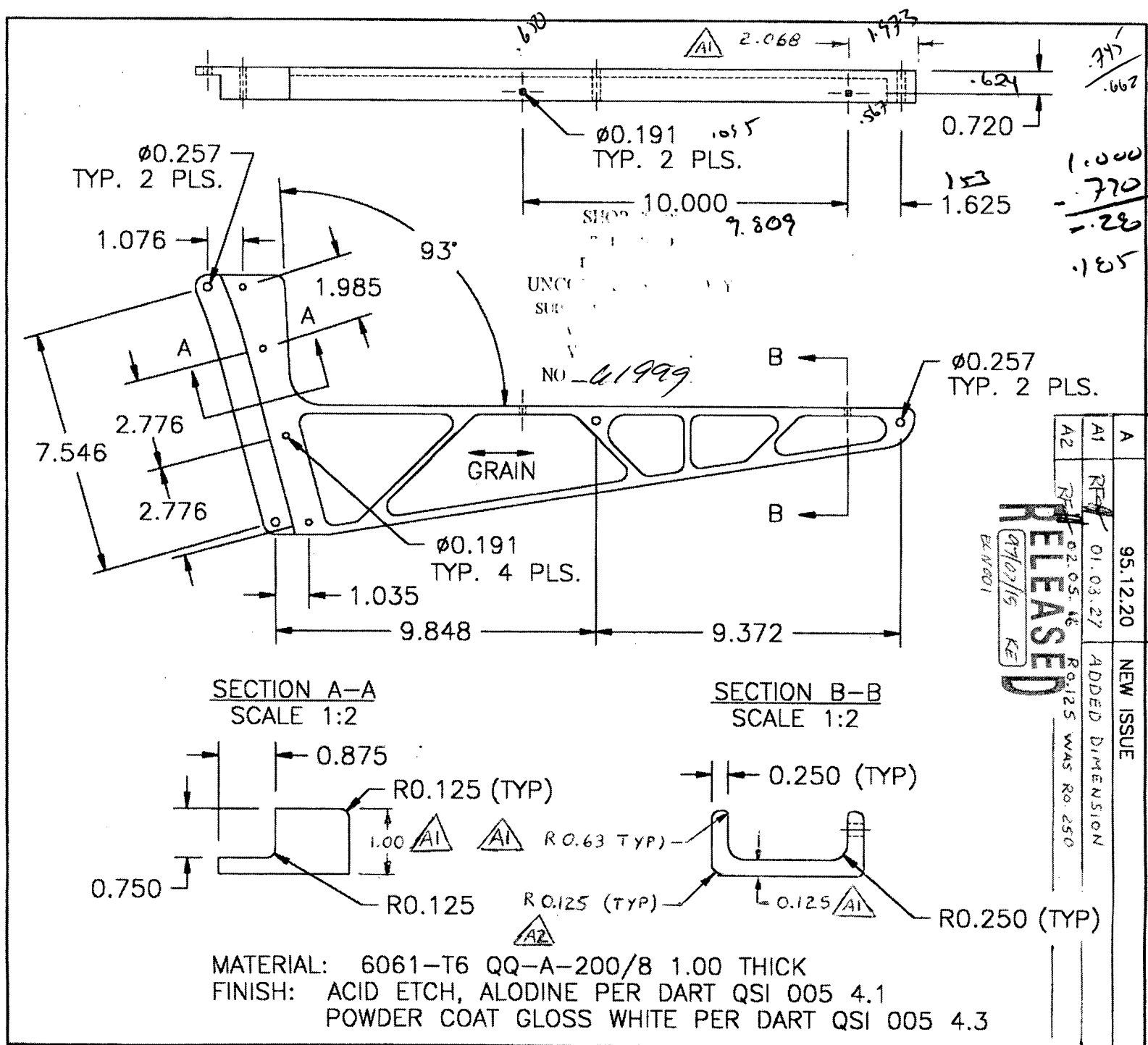
NOTE: Date & initial all entries

**DART**



DESIGN	DRAWN BY	DART AEROSPACE LTD
B-2	KE	VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	APPROVED	DRAWING NO.
✓	✓	D2523
DATE	TITLE	REV. A
95.12.20	MOUNTING BRACKET	SHEET 1 OF 1
	NEW ISSUE	SCALE 1:4

**RELEASED**  
9/10/15 KE  
EX 1001



Copyright 1995 by DART AEROSPACE LTD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries